

Work Order ID 65749

Tuesday, January 25, 2011 10:22:59 AM



Page 1

Item ID: D2432

Accept



Setup Start



Revision ID:

Item Name: 206 (24") Bearpaw

Stop



Start Date: 1/24/2011 Start Qty: 8.00



Cust Item ID:

Required Date: 1/31/2011 Req'd Qty: 8.00



Customer:

Reference:

Approvals:

Process Plan:

[Signature]

Date: 11-01-25

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D2432

Rev F3

120

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

Cut Blank as per D2432 File

11-2-10

8

130

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1-Inspect material for defects or damage prior to machining
2-Machine as per Folio and Dwg D2432 Identify as D2432F
3-Deburr

11/03/15

8

140

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

11/03/15

*Batch
Peg. 1/11*

W/O:		WORK ORDER CHANGES					
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Page 2

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

ml 11/03/15

8

8

151

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

0.00

Packaging

PPP67170

11/3/16 8

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/3/16 8

mf
11-03-16

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Picklist Print

Tuesday, January 25, 2011 10:23:06 AM

Page 1

Work Order ID: 65749

Parent Item: D2432

Parent Item Name: 206 (24") Bearpaw


Start Date: 1/24/2011

Required Date: 1/31/2011

Start Qty: 8.00

Required Qty: 8.00

Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MUHMWB10  UHMW 1" Black		Purchased	No			120	sf	189.8794	3.7	29.6			

1311-2-10

Location

Loc Qty

Loc Code

MAT

189.8794

114624

5.2734

115325

15.506

115955

38.8

116281

13

116554

117.3

116796

116796

8

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DART AEROSPACE LTD		Work Order:	65749
Description: Bearpaw		Part Number:	D2432
Inspection Dwg: D2432 Rev: F3		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet Drawing Dimension		Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	0.063 x 45°	+0.030/-0.010	.06 x 45°	/		vern JL-3	
B	5.500	+/-0.030	5.505	/		"	
C	0.200	+/-0.030	.195	/		"	
D	0.25 x 45°	+/-0.030	.26 x 45°	/		"	
E	R0.250	+/-0.030	.250	/		R-G	
F	0.250	+/-0.010	.250	/		"	
G	0.625	+/-0.030	.626	/		"	
H	0.375	+/-0.010	.380	/		"	
I	0.950	+0.030/0.010	.953	/		"	
J	19.000	+/-0.030	19.00	/		m-type	
K	3.14	+/-0.030	3.150	/			
L	3.28	+/-0.030	3.290	/			
M	Ø0.260	+0.005/-0.000	.260	/			
N	Ø0.93	+/-0.030	.925	/			
O	0.30	+0.030/-0.000	.313	/			
P	23.750	+/-0.030	23.750	/		m-type	
Q	7.375	+/-0.030	7.380	/		vern CNC-02	
R	4.250	+/-0.010	4.250	/		"	
S	2.000	+/-0.030	1.999	/		"	
T	9.000	+/-0.010	9.00	/		"	
U	9.000	+/-0.010	9.00	/		"	
V	0.375	+/-0.010	.378	/		"	

Measured by:	JL	Audited by:	ML	Prototype Approval:	N/A
Date:	11/03/14	Date:	11/03/15	Date:	

Rev	Date	Change	Revised by	Approved
A	04.01.09	New Issue P/O K10008/D206-559-015	KJ/RF	JF

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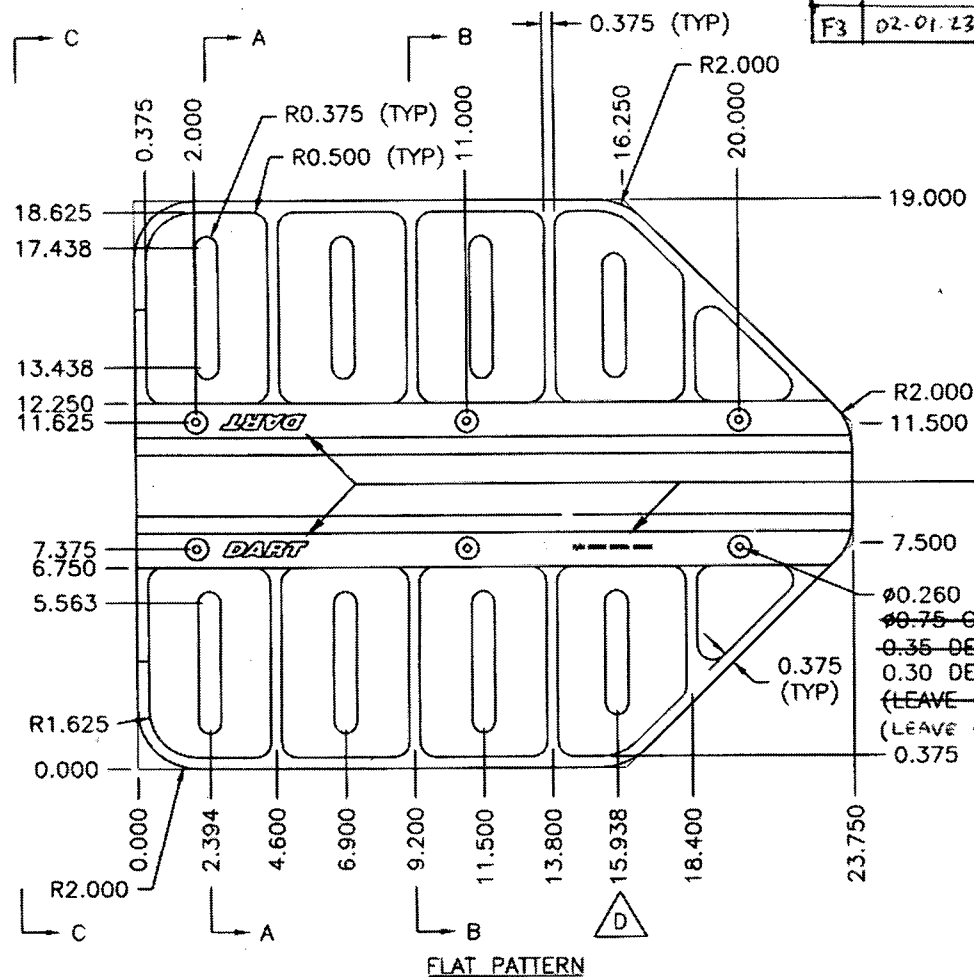
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F1	99.03.03	ADD DEC 9143
F2	01.03.28	Ø0.93 WAS Ø0.75 RF
F3	02.01.23	CLARIFY CORE DIMS RF



ENGRAVE LOGO TO MAX DEPTH OF 0.012. ENGRAVE PART AND BATCH NUMBERS TO MAX DEPTH OF 0.010. (TYPICAL LOCATION AS ILLUSTRATED)

Ø0.260 (TYP)
~~Ø0.75 C'BORE~~ Ø0.93 C'BORE
 0.35 DEEP FROM TOP (MIN.)
 0.30 DEEP FROM BOTTOM
 (LEAVE 0.300 MIN.)
 (LEAVE 0.650 MIN.)
 0.375

EFFECTIVE DEOS



RELEASED
 99.06.17 KE

SHOP COPY
 RETURN TO
 ENGINEERING
 CONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 65749
 2/11-0-25



DESIGN	DRAWN BY	DART AEROSPACE LTD
KE	KE	HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
KE	KE	D2432
DATE	TITLE	REV. F
98.05.12	BEARPAW	SHEET 1 OF 2
A	95.10.31	NEW ISSUE
B	96.01.24	RE-DESIGN
C	96.03.26	CHANGE BORE AND C'BORE DEPTH
D	96.06.04	MOVE SLOT
E	97.02.27	CHANGE C'BORE DEPTH, BORE RADIUS
F	98.05.12	CHANGE C'BORE, ADD B AND F P/N
1:6		SCALE

MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689
 1.00 THICK (MACHINE TO 0.950)

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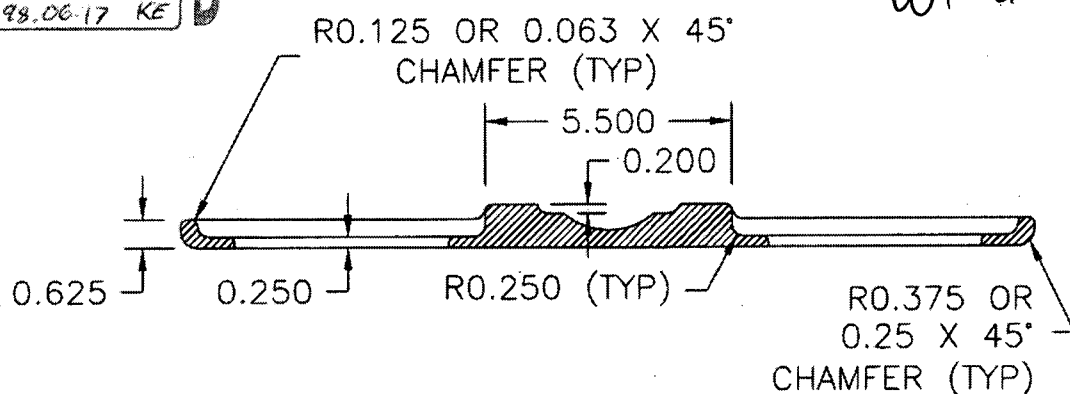
NOTE: Date & initial all entries



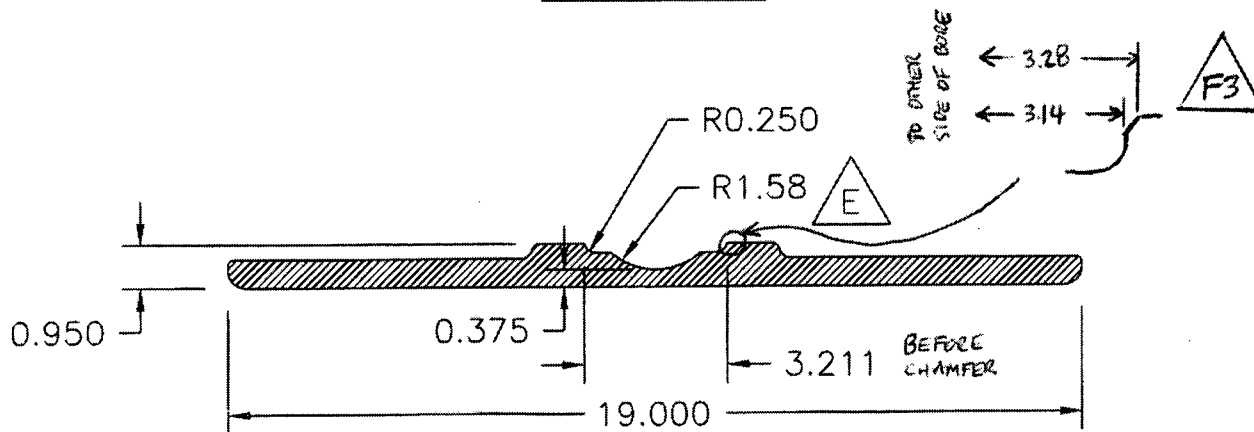
DESIGN KE	DRAWN BY KE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D2432	REV. F SHEET 2 OF 2
DATE 98.05.12	TITLE BEARPAW		SCALE 1:4

RELEASED
98.06.17 KE

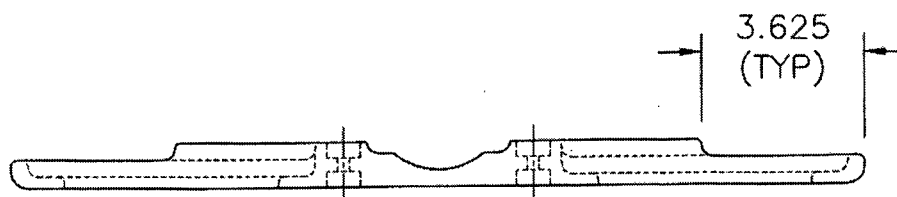
W1065749



SECTION A-A



SECTION B-B



SECTION C-C

W/O:		WORK ORDER CHANGES					
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